

UNPAINTED

Dart Aerospace Ltd.

Date: Thursday, 21/08/2008 5:15:46 PM  
User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 41581  
Estimate Number : 12485  
P.O. Number :  
This Issue : 21/08/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : CROSSTUBES  
Previous Run : 41580  
Written By :  
Checked & Approved By : JUD 08.8.22  
Comment : Est Rev:A New Issue 06-07-05 JLM  
Est Rev:B Update qty of MS21042L5 06-09-12 KJ  
Est Rev:C Rev B 07-11-15 DD  
Est Rev D Combined manufacturing 08.04.02 EC verified by:  
DD  
Est Rev:E 08-06-24 revD as per dwg DD verified by:EC

Drawing Name : 350/355 AS X-TUBE FWD  
Part Number : D350748101UP  
Drawing Number : N/A  
Project Number : N/A  
Drawing Revision : D  
Material :  
Due Date : 10/09/2008 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



for JUD 08.8.28



Comment: Photocopy bluefile &amp; type labels per PPPD350-748-101

CHG001

5 02612/4

2.0

D350748141TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch: B-42399

MB

08-11-20

3.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

08-11-20

4.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08-11-20

5.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs,  
Set-up drill table as per QSI 010

2-Deburr

RT 08-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 21/08/2008 5:15:46 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 41581

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Engrave Part # and Batch # as per Dwg D350-748-141

ET 08-11-20

4-Remove all marks from tube within limits of D350-748-141

JB 8-11-20

5- Apply a light coat of LPS3 on the interior of tube

Batch: M109539

ET 08-11-21

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

808/11/21 (40)

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7692

cd 08/11/25 0

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

P. 8/12/08 C

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/12/08 (41)

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

ET 08-12-08

2-Prime Outside of Tube as per Dart QSI 005 4.2

DO NOT PAINT-PRIMED ONLY

ASSEMBLY PRIMED ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Thursday, 21/08/2008 5:15:46 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 41581

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

ml 08 12 09 (1)

12.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch: 35783

ml 08 12 09

13.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

ml 08 12 09

14.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch: 100621

ml 08 12 09

15.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch: 105442

ml 08 12 09

16.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 107501

ml 08 12 09

17.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

Batch: 18836

ml 08 12 09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 41581

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

m 08 12 09 (1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08 12 09 (1)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

21.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
350 SADDLE  
Batch: B35781

36016

43423

SP

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
BUSHING  
Batch: B39720

SP

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Bolt  
Batch: M108558

SP

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
bolt  
Batch: M109061

81210

(X) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 41581

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

SP

26.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M109249

M108827

M108161

SP

27.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M107534

M108672

M109282

SP

28.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108145

SP

29.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

M10810

SP

30.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/12/4

31.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-101

Location:

PPP Rev: B

8/12/11

(1x)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 41581

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 *af*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.12.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

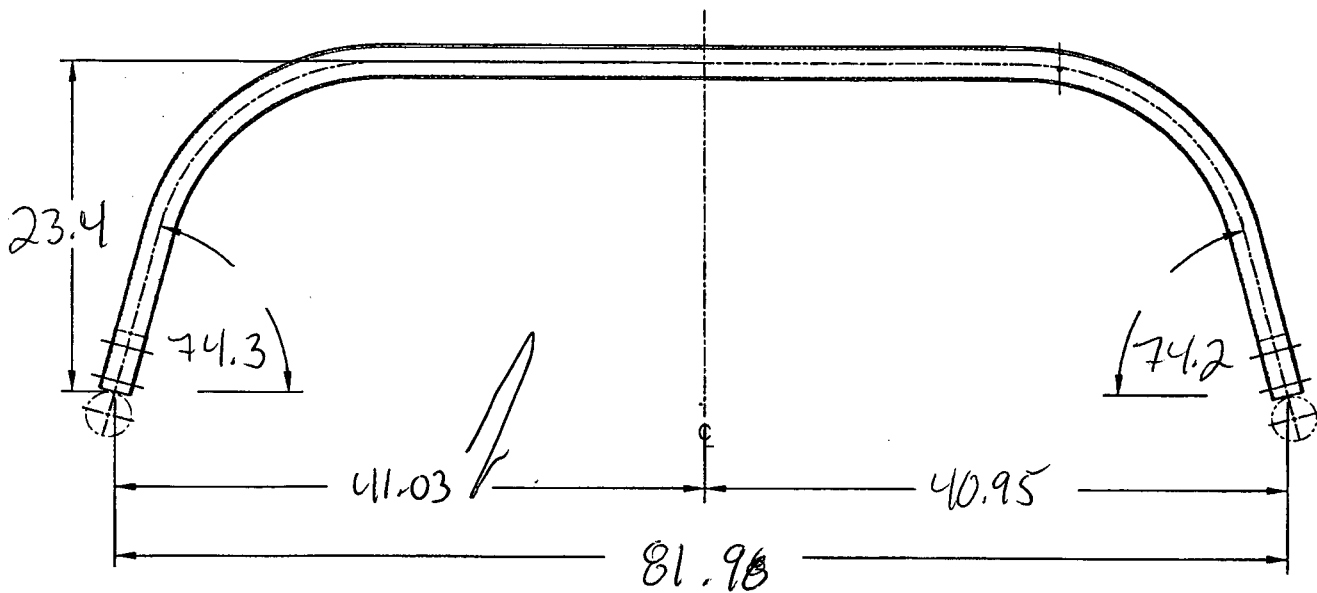
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41581
<b>Description:</b> Crosstube High Fwd (AS350/355)		<b>Part Number:</b> D350-748-101
<b>Inspection Dwg:</b> D350-748-141	<b>Rev:</b> D	<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	
Date	08-11-20

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *HA*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125  
FINISHED LENGTH = 110.27±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 41581

**UNDER REVIEW!**

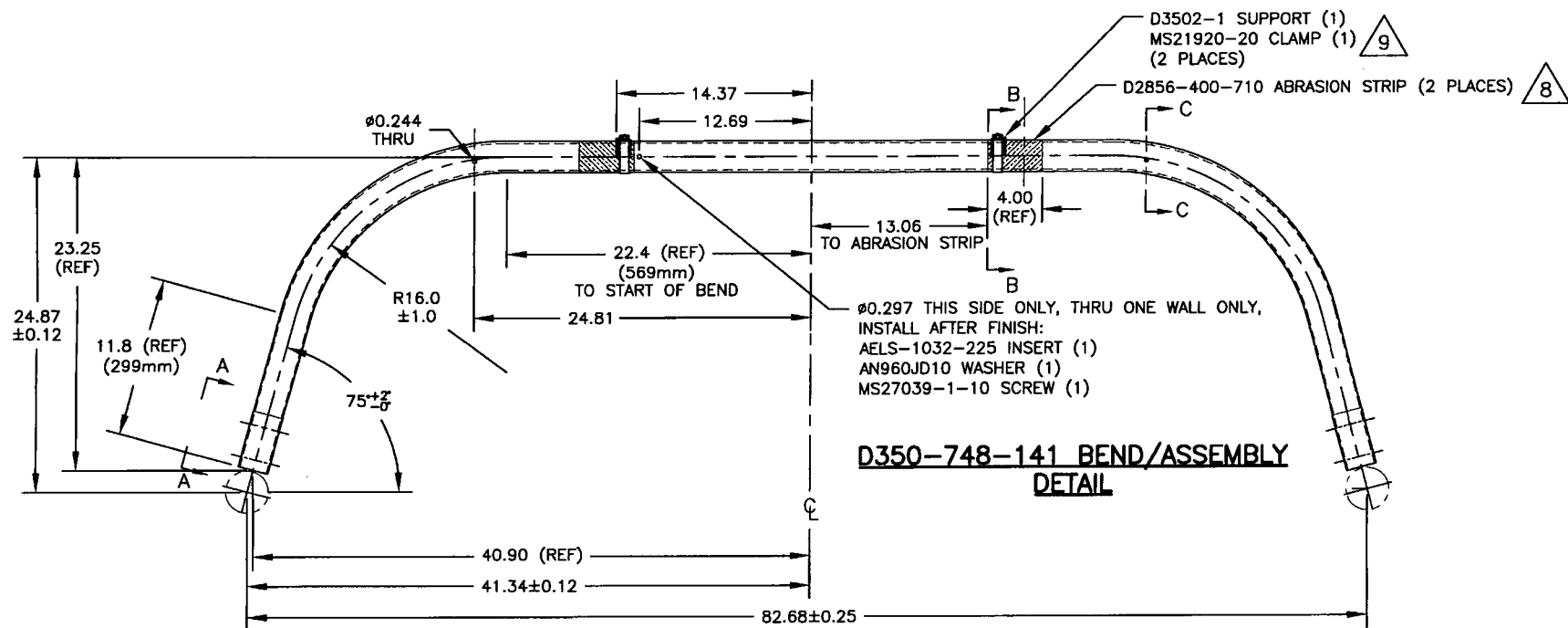
07.02.16 *HA*

CUFF JENK REDUCED

07.07.22

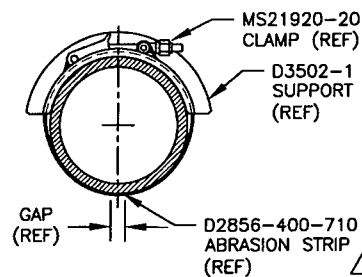
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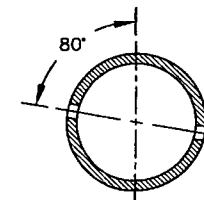
### SECTION B-B

SCALE 1:2



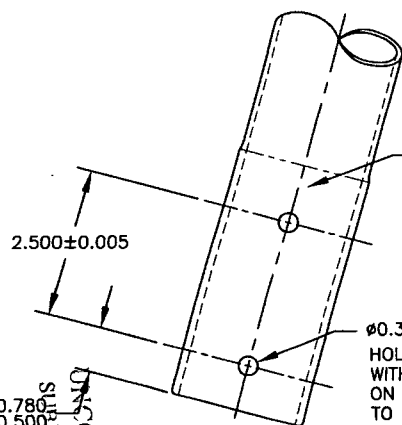
### SECTION C-C

SCALE 1:2



### VIEW A-A

SCALE 1:2



HOLE TO BE ALIGNED WITHIN  $\pm 0.001$  OF HOLE ON OTHER SIDE OF CUFF, TO BE DRILLED AFTER BENDING

UNDER REVIEW

07.02.16.17  
CUFF FROM REWORK  
06.07.14.22

RELEASED

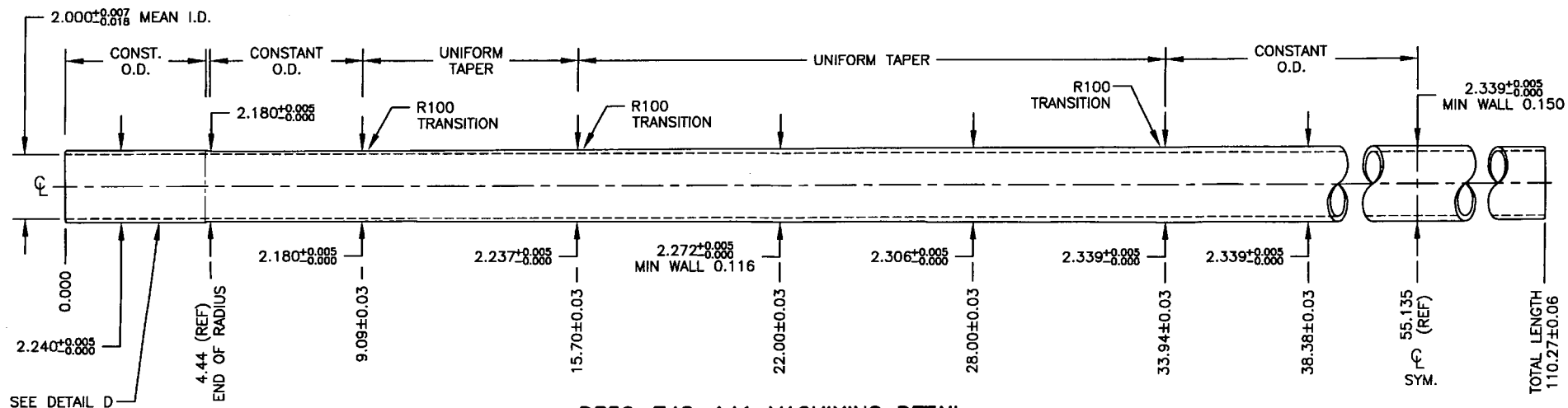
06.10.31.17

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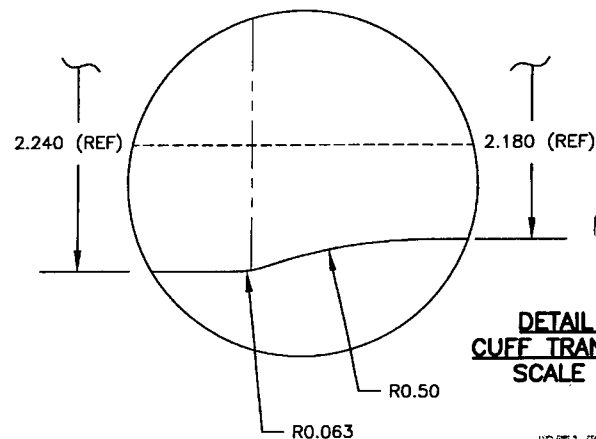
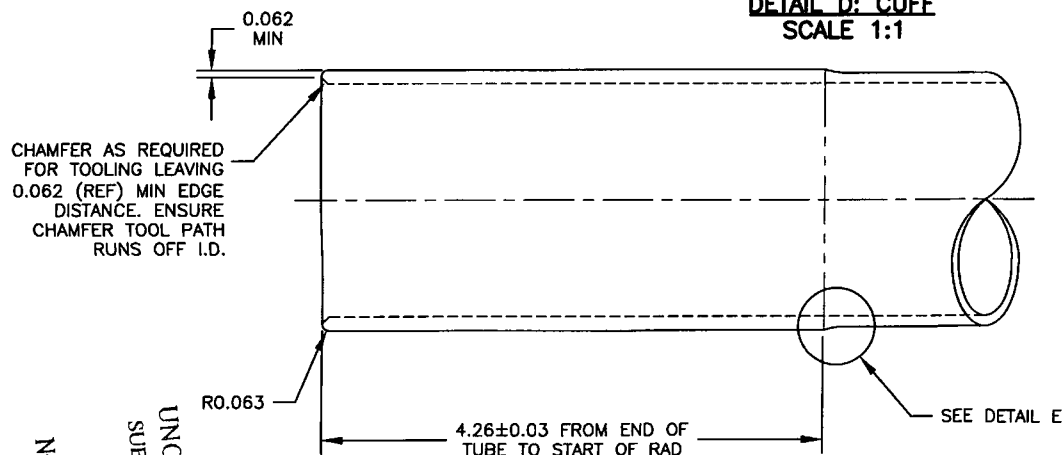
DESIGN	q9	DRAWN BY	q9	<b>DART</b>	DART AEROSPACE LTD. HAMMERSLEY, OXFORD, CHAMPA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI FWD)	D350-748-141	SHEET 2 OF 3
					SCALE 1:2

NO. 41581  
WORK ORDER  
SUBJECT TO AMENDMENT  
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ENGINEERING  
RETURN TO  
SHOP COPY



### D350-748-141 MACHINING DETAIL

#### DETAIL D: CUFF SCALE 1:1



UNDER REVIEW

#### DETAIL E: CUFF TRANSITION SCALE 9:1

RELEASED  
06.10.31

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DESIGN

90

DRAWN BY

90

**DART**

DART AEROSPACE LTD.  
WARRICKS, ONTARIO, CANADA

CHECKED

#

APPROVED

#

DRAWING NO.  
D350-748-141

REV. 0  
SHEET 3 OF 3

DATE

06.10.31

TITLE

CROSSTUBE (AS 350/355 HI FWD)

SCALE

1:3

NO 41581  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY



# Packing Slip



## Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

42164

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

<b>Sold To:</b> Dart Aerospace Ltd. 1270 Aberdeen St.  Hawksbury, ON K6A 1K7
<b>ShipTo:</b>

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
7642	Nov-25-2008	NET 30 DAYS	10071 6547 RT0001		Dec-04-2008

Item # Qty P/N & Description

1	1 EA <del>KIP</del> SKID	S/N B41581
	P/N d350-748-101	W/O 82024

**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Dec-04-2008

**CONSIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 82024  
**INVOICE #:** 42164

**CONTRACT OR  
PURCHASE ORDER #** 7642

**DESCRIPTION:** ~~SKID~~

**QTY** 1

**P/N #** d350-748-101

**S/N #** B41581

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART # 9878. MPI  
INSPECTED IAW ASTM E 1444. CADMIUM PLATED IAW AMS-QQ-P-  
416B, TYPE 2 YELLOW, CLASS 1 . HEAT CHART # 9911.**

*Solid  
08/12/08*

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**

